

Work Order ID 53493

November 6, 2009 10:46:32 AM



Page 1

Item ID: D3852-041

Accept



Setup Start



Revision ID: A

Item Name: Rib Assembly

Stop



Start Date: 12/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 12/11/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

RL

Date:

12-11-6

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3852	Rev A								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440
jig □ 2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as
per dwg D3852 □ 3- c/sink hole as per dwg □ 4- remove identification
markings □ 5- deburr

SAD

02-11-10

2

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2

02-11-11

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld D3759-1 bushing as per dwg D3852 □ A/R ER316 S.S. Rod
Batch: *44109213* □ 2- grind bushing weld flush as per dwg dwg
D3852 □ 3- deburr hole if necessary

02-11-12

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November 6, 2009 10:46:32 AM



Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
						PD 09.11.12	2		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
						2			09.11.13
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>Basket</u> Memo	0.00 0.00							
						PD 09.11.16			

Work Order ID 53493

November 6, 2009 10:46:32 AM



Page 3

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Cust Item ID:

Required Date: 12/11/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21 - Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09/11/16 JF

mf 09-11-16

Picklist Print

November 6, 2009 10:46:37 AM

Page 1

Work Order ID: 53493

Parent Item: D3852-041RevA

Parent Item Name: Rib Assembly

Comments:

Start Date: 12/11/2009

Required Date: 12/11/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3166-3RevA1

Manufactured

No

100

Each

6.2421

0.3789



Basket Hoop

SAP 09-11-10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

6.2421

50033

0.0527

50618

0.1894

52058

6

0.3789

D3759-1RevA

Manufactured

No

100

Each

30.0000

2.0000



Bushing

6/10/11/12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

30

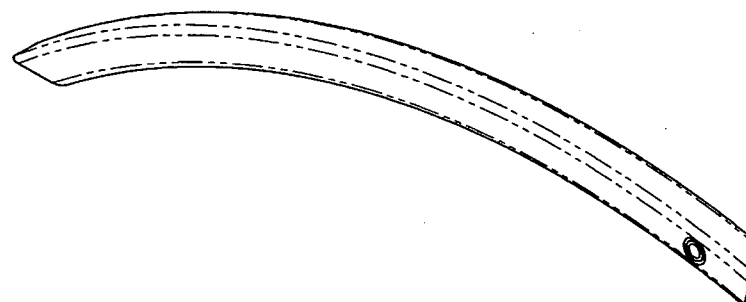
51473

30

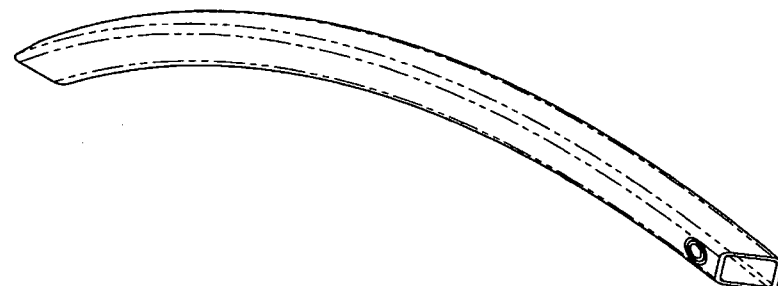
② ✓

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53493
P09-11-C

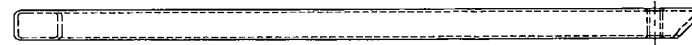
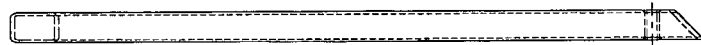
RELEASE
08/11/07 MP

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs EACH
 - 8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

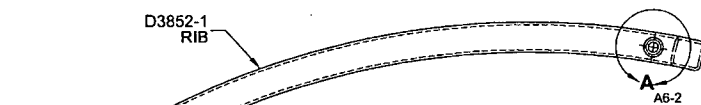
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TITLE RIB ASSEMBLY	SCALE NTS
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8 7 6 5 4 3 2 1



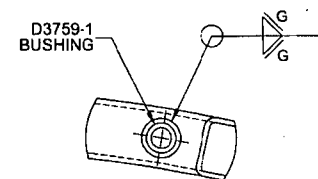
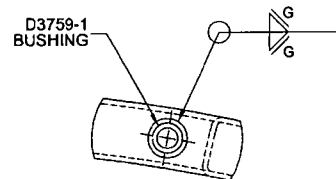
D3852-1
RIB

D3852-2
RIB



D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY



DETAIL A
SCALE 2X C5-2

DETAIL B
SCALE 2X C2-2

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	185	DRAWING NO.	REV. A
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